



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400214
Job Sheet 180452



Part No: RBT400214

Job Qty: 1 ea

Part Name: Trim Tab Bending Gauge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400214 Rev. 7 IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	1 pcs	7/13/18	7/13/18	0.00	1.00	Small Fab-9		MLC DAS
110	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC5		NOV 12 2018 68
120	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		21 9-89
130	QC21-FG	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21		NOV 12 2018

Part Op 100 - Assemble Per Drawing; 1-Cut -13 and -19 tape as per DWG. 2-APPLY -19 TAPE FOR SPRING CLIP TO -5.
Descriptions: SPRING CLIP & -13 TAPE STOP TO -1 FRAME WELDMENT. 3-RIVET -3 DOUBLER & -5 SPRING CLIP TO -1 FRAME WELDMENT.
120 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
93878A146	Self Threading Pan Head Screw	3 Ea (3 ea)	90-Start up Operation	5032755
AN960-6	Flat Washer	3 Ea (3 ea)	90-Start up Operation	Fm137391
RBT400214-1	Frame Weld Mount	1 Ea (1 ea)	90-Start up Operation	5124276
RBT400214-17	Bearing 3/8 X 3/4" Black Nylon Or Delrin	3 Ea (3 ea)	90-Start up Operation	5108680
RBT400214-3	Doubler	1 Ea (1 ea)	90-Start up Operation	5098828
RBT400214-5	Spring Clip	1 Ea (1 ea)	90-Start up Operation	5098823
76475A92	Low-Friction Surface-Protection Tape w/Teflon PTFE, Extra-Tough, .1660 ft (.166 ea)	2" Wide x 0.022" Thick x 3' Long	90-Start up Operation	5068057
AN470AD-4-6	Rivet	4 (4 ea)	90-Start up Operation	Fm133077-50

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	76475A92	0	3	0
	93878A146	3	100	0
	AN470AD-4-6	4	0	0
	AN960-6	3	500	0
	RBT400214-1	1	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER :			

RBT400214-17
RBT400214-3
RBT400214-5

3
1
1

0
0
0

0
0
0

Part Specifications

Specifications could not be found.

Plex 7/6/18 10:40 AM Dart.lajeunesse.marie



Container No: S126828



Part: RBT400214

Job No: 180452

Serial No/Batch: S126828

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/12/18

DQA: _____ Date: _____



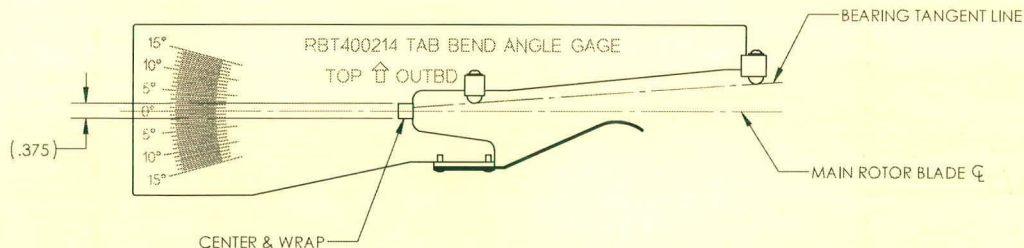
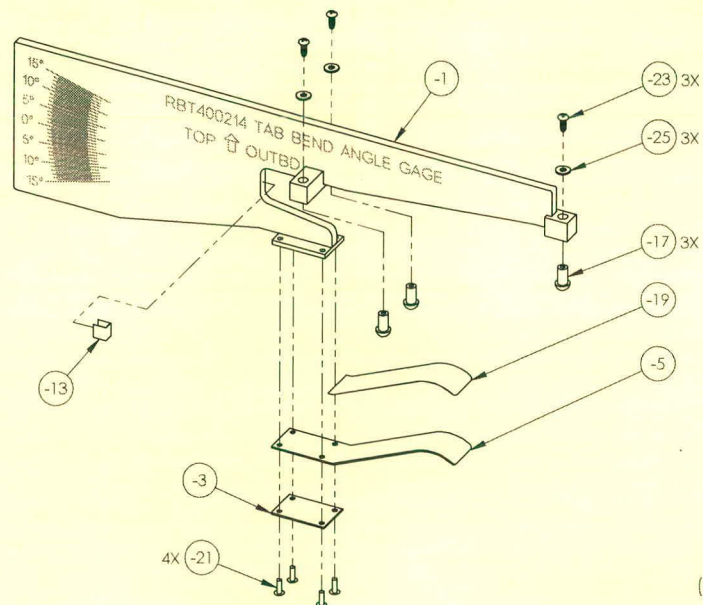
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube</td><td style="width:12.5%;">Cross tube</td><td style="width:12.5%;">Water Jet</td><td style="width:12.5%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
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Root Cause		FAULT CATEGORY																							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐														
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐														
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐														
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐														
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐														
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐														
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐														
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐														
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐														
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐														
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :																					
Misidentified	☐	Past Due	☐																						

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 180452 MW
180706

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		INSTALLED NEW TITLE BLOCK & BOM FORMAT, CHANGED P/N FROM 207-215-002-101, AND ALTERED FROM ONE (1) PAGE TO THREE (3) PAGES. ALSO ADDED HARDWARE AND ASSY. DWGS, CREATED -1 WELDMENT, ADJUSTED -11 POSITION UP .046 TO CORRECT ALIGNMENT.	10/30/2007	WP	RW
2		MADE INTO FOUR PAGES, ADJUSTED BEARINGS UP .090 TO MATCH PURCHASED UNIT. -5 SPRING END WAS R1.125, & ADDED R.125 CORNERS. -11 GROOVE DEPTH WAS .188.	1/28/2008	WP	DW
3		REPLACED ANGLE GAUGE ENGRAVING WITH A PLACARD, CREATED A POCKET FOR PLACARD IN FRAME PER S.E. SEPARATED PARTS TO INDIVIDUAL SHEETS. CHD FINISH FROM POWDER COAT SAFETY YELLOW, DELETED -7 FROM NOTE 2 ON SHEET 1.	4/27/2011	RJC	RW
3A		ADDED 8/O TO -19 IN BOM. CHD -1 FINISH FROM ANODIZE BLACK PER R.W.	8/25/2011	PJC	RW
4		DELETED POCKET FOR -21 & REFERENCE MARKS. ADDED MACHINE ENGRAVE GAUGE LINES & LETTERING PER S.E.	6/28/2012	PJC	SE
5		-9 & -11 CHD DIM WAS .250 E .250 + .005/- .000.	2/24/2013	BIM	SE
6		-9 CHD DIM WAS .500 E .500.	3/22/2013	BIM	SE
7	16-0240	UPDATED TO NEW STANDARD. ADDED OEM REF. ADDED DASH NUMBERS TO 8/O PARTS. -1 DELETED DIMS 15.250, 2.150, .089-.095, .203, 1.550, .694, (.190), ADDED DIMS .38, (.100), ADDED FIXTURE RBT400214-1-F NOTE. -3 CHD DIMS WAS .040 B .04, WAS 1.000 B 1.00, WAS 1.500 B 1.50, WAS 4X .0128 B 4X .0128 + .005-.000, ADDED DIMS 2X .15, 2X .15. -5 CHD DIMS WAS 5.202 B 5.20, WAS 1.170 B 1.17, WAS 1.750 B 1.75, WAS .040 B .04, WAS 1.000 B 1.00, WAS 4X .0128 B 4X .0128 + .005-.000, WAS 2X R.125 B 2X R.125, WAS (.455) B (.455), WAS 1.200 B 2X 1.200 ± .005, WAS .700 B 2X .700 ± .005, WAS 1.500 B 2X 1.50, DELETED DIM (.38), ADDED DIM 2X .15. CHD TOLERANCES WAS ± .005 E ± .010, WAS ± .01 E ± .03. -7 CHD DIMS WAS .125 B .13, WAS 4X .0128 B 4X .0128 + .005-.000, WAS 1.000 B 1.00, WAS 1.500 B 1.50, WAS .700 B 2X .700, WAS 1.200 B 2X 1.200, ADDED DIMS 2X .15, 2X .15. -9 CHD DIMS WAS .500 E .50, WAS .500 E .53, WAS .200 + .005-.000 E .F. -13 B .260-.267 E .F. -15, WAS .425 B .43, WAS .500 B .50, WAS 2.250 B 2.250, 251 THRU ALL (S.F. -17), -11 CHD DIMS WAS .500 B .50, WAS .500 B .50, WAS 2.000 B 2.00, WAS .250 + .005-.000 E .F. -13 B .260-.267 (S.F. -15), WAS 2X .0128 B 2X .0128 ± .005 (S.F. -17), ADDED DIMS .35, 2X .25, -13. -19 ADDED 8/O REF (PORT PLASTICS #6093-10), ADDED DRAWING. -15 CHD DIMS WAS 3X R.062 B 3X R.06, WAS 4.250 B 4.25, WAS 3.000 B 3.00, WAS 6.900 B 6.90, WAS R4.400 B R4.40, WAS R4.650 B R4.65, WAS R4.900 B 4.90, WAS .032 B .03, WAS 2.040 B 2.04, WAS 5.857 B 5.86, WAS .500 B .50, WAS 1.100 B 1.10, WAS 15.250 B 15.25, WAS 250 B 25, WAS R.250 B R.25, WAS 1.875 B 1.86, WAS 1.375 B 1.38, WAS 1.000 B 1.00, WAS .032 B .03, DELETED DIM 1.021, ADDED DIM .991, ADDED ENGRAVE S/N. "MADE IN USA" NOTE. -17 CHD MATL WAS BLACK NYLON OR DELRIN B BLACK NYLON/DELPHIN/ACETAL CHD DIMS WAS .440 B .46, WAS 0.250 B 0.248-.249 (S.F. -9 & -11), WAS 0.110 B .375 B 0.110 B .38, WAS R.190 B R.19, ADDED DIM .190. -19 WAS 8/O B MANUFACTURED. -23 ADDED 8/O REF #75878A.46.	12/1/2016	DPD	JAG

NOTES:

1. APPLY -19 TAPE FOR SPRING CLIP TO -5 SPRING CLIP & -13 TAPE STOP TO -1 FRAME WELDMENT.
2. RIVET -3 DOUBLER & -5 SPRING CLIP TO -1 FRAME WELDMENT.
3. REF. BELL T/N: 407-215-002-101.

DART
AEROSPACE

TITLE TRIM TAB BENDING GAUGE

DWG NO.	RBT400214	REV	7
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
TREAT	.XXX ± .005 FRACTIONS ± 1/8		
FINISH	.XX ± .01 ANGLES ± 5°		
SPEC	.X ± .1 SURFACES ± 125°		
DRAWN BY:	COLE	1. BREAK ALL SHARP EDGES R15 X 45° OR R15R	
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DA APPR:	LINDSAY	USED ON MODEL	
APPROVED:	GILBERT	BELL 407	
SCALE	1:3	DATE	4/9/2001
		SHEET	1 OF 11

DQA: _____ Date: _____



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : _____			